

Work Order ID 56863



Page 1

March 11, 2010 10:47:49 AM

Item ID: D3805-3

Accept



Setup Start



Revision ID:

Item Name: Plate

Stop



Start Date: 11/03/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 18/03/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: MDate: 10-3-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
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D3805	Rev A								
-------	-------	--	--	--	--	--	--	--	--

100		0.00							
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--	--	--	--	--	--	--	--	--	--

Waterjet	Memo	0.00							
----------	------	------	--	--	--	--	--	--	--

FLOW CNC Waterjet	1-Cut as per Dwg D3805								
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Dwg Rev: AProg Rev: AAB 10-3-304

2-Deburr if necessary

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
-----	---	------	--	--	--	--	--	--	--

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QC	Memo	0.00							
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Quality Control									
-----------------	--	--	--	--	--	--	--	--	--

AB 10-3-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56863

March 11, 2010 10:47:49 AM



Page 2

Item ID: D3805-3

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Setup Start



Revision ID:

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Stop



Start Date: 11/03/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 18/03/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

8.003130

X4

130



Brake NC

Memo

0.00

4

Brake NC

Form as per Dwg D3805 using Jigs DT8261 and DT8326

8B 10/03/31

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8.003131

X4

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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March 11, 2010 10:47:49 AM



Page 3

Item ID: D3805-3

Accept



Setup Start



Revision ID:

Item Name: Plate

Stop



Start Date: 11/03/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 18/03/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

150



Identify as per dwg & Stock Location: W/A

Packaging

Packaging

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

EZ 10-4-5 (X4)

QC

Quality Control

Memo

0.00

10/04/06 (H)

10-4-5 (H)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 11, 2010 10:47:53 AM

Page 1

Work Order ID: 56863



Parent Item: D3805-3



Parent Item Name: Plate

Start Date: 11/03/2010

Required Date: 18/03/2010

Comments: IPP Rev:A 08-07-15 new issue DD verified by:EC
IPP Rev:B 08-07-29 new flat pattern DD verified by:EC

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S18GA		Purchased		No		100	sf	225.4922	6.6821			

304/316 .050 Sheet

130-3-30

Warehouse

Location

Main Warehouse

MAT	225.4921632
108156	0.98526316
111743	23.7174
112885	72.7895
113062	128

Loc Qty

Loc Code

4

112885

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	54863
Description: Wearplate	Part Number:	D3805-3
Inspection Dwg: D3805	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	HB	Audited by:	S	Prototype Approval:	N/A
Date:	10-3-30	Date:	10/03/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.19	New Issue	KJ	MM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

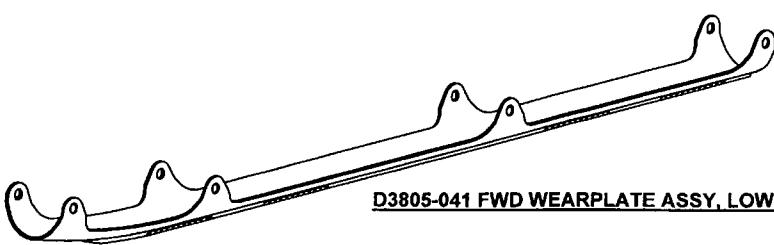
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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

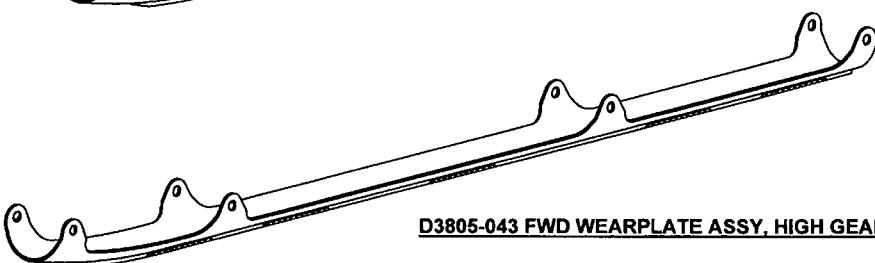
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D



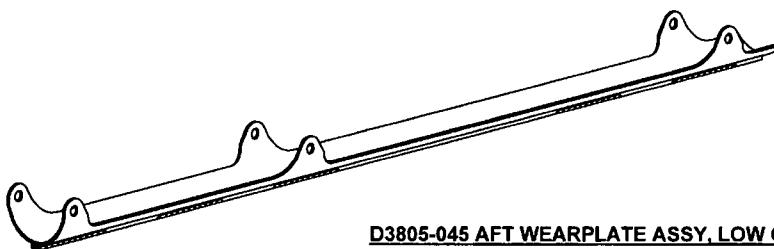
D3805-041 FWD WEARPLATE ASSY, LOW GEAR

C



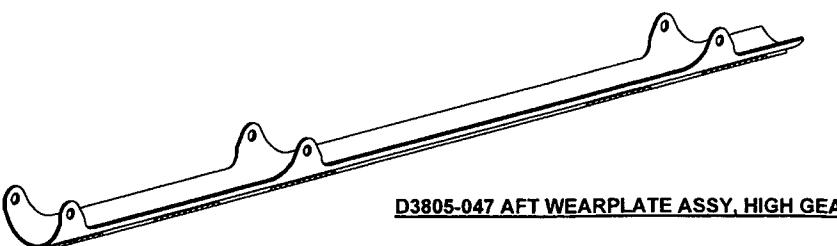
D3805-043 FWD WEARPLATE ASSY, HIGH GEAR

B



D3805-045 AFT WEARPLATE ASSY, LOW GEAR

A



D3805-047 AFT WEARPLATE ASSY, HIGH GEAR

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
19	1				D3807-1	GASKET
20		1			D3807-3	GASKET
21			1		D3807-5	GASKET
22				1	D3807-7	GASKET
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 56863
08-0-3-11

RELEASED
GP 09-03-03
per ECN 09-538

REV.	NEW ISSUE	MB	08.11.21
DESCRIPTION		BY	DATE
DESIGN	P		
DRAWN	A		
CHECKED	AS		
MFG. APPR.	DA		
APPROVED	AS		
DE APPR.	AS		
DATE	08.11.21	SCALE	NTS

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

REV. A
SHEET 1 OF 8
WEARPLATE ASSY
NTS

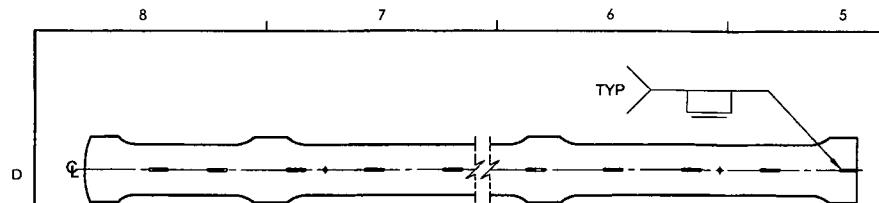
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

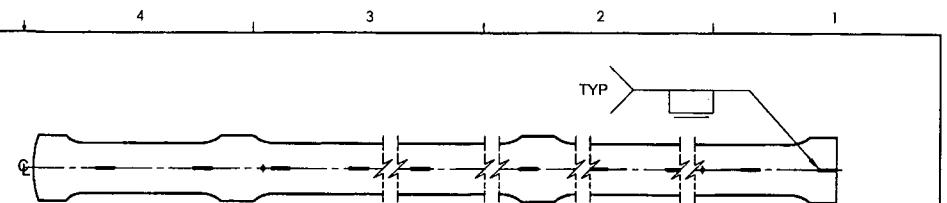
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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

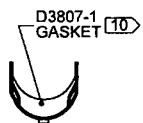
NOTE: Date & initial all entries



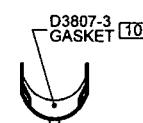
D3805-041 FWD WEARPLATE ASSY, LOW GEAR



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



VIEW A-A C5-2



VIEW B-B C1-2

RELEASED
(09-03-07)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3805-041 = 3.79 lbs; D3805-043 = 4.36 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

DESIGN	49	DART AEROSPACE USA, INC.
DRAWN	b	PORT HADLOCK, WA
CHECKED	AS	
MFG. APPR.	M	DRAWING NO. REV. A
APPROVED	M	D3805 SHEET 2 OF 8
DE APPR.	M	TITLE SCALE
DATE	08.11.21	WEARPLATE ASSY NTS

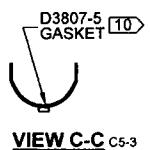
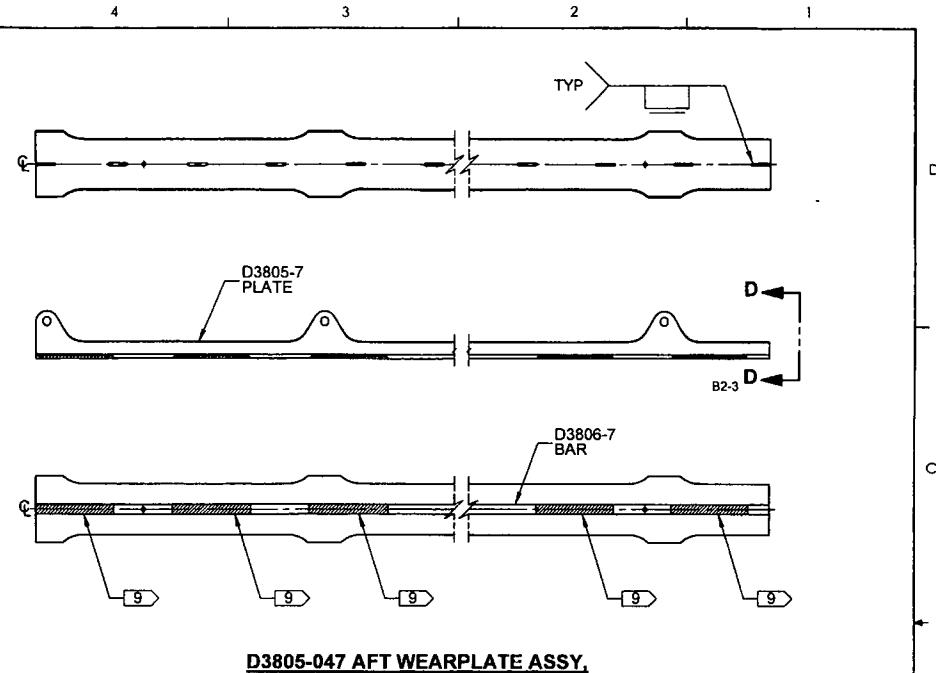
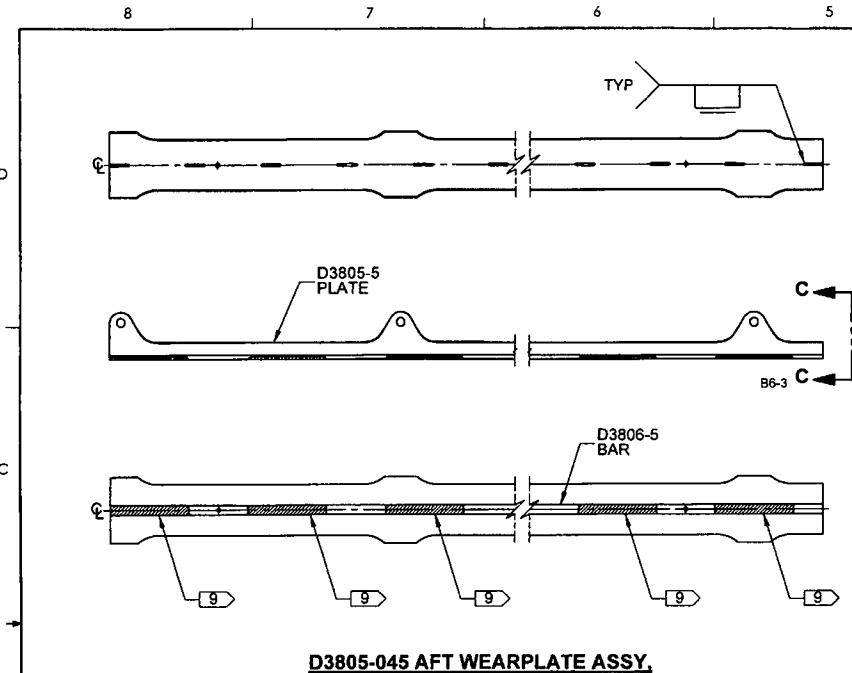
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
QP 09.03.20

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3805-045 = 3.93 lbs; D3805-047 = 4.21 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

DESIGN	10	DART AEROSPACE USA, INC.
DRAWN	10	PORT HADLOCK, WA
CHECKED	10	
MFG. APPR.	10	REV. A
APPROVED	10	SHEET 3 OF 8
DE APPR.	10	TITLE
DATE	08.11.21	SCALE
		WEARPLATE ASSY
		NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

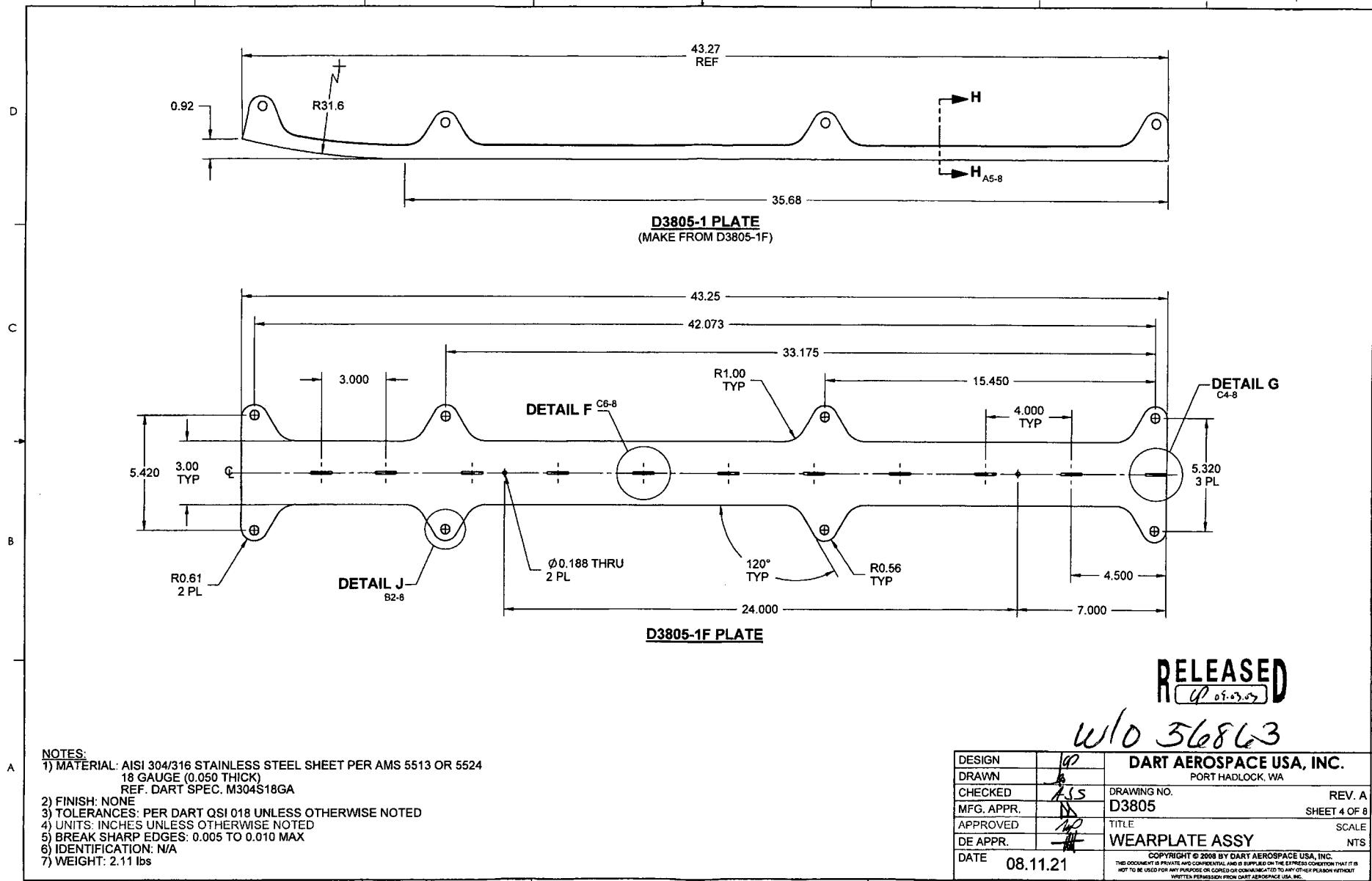
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

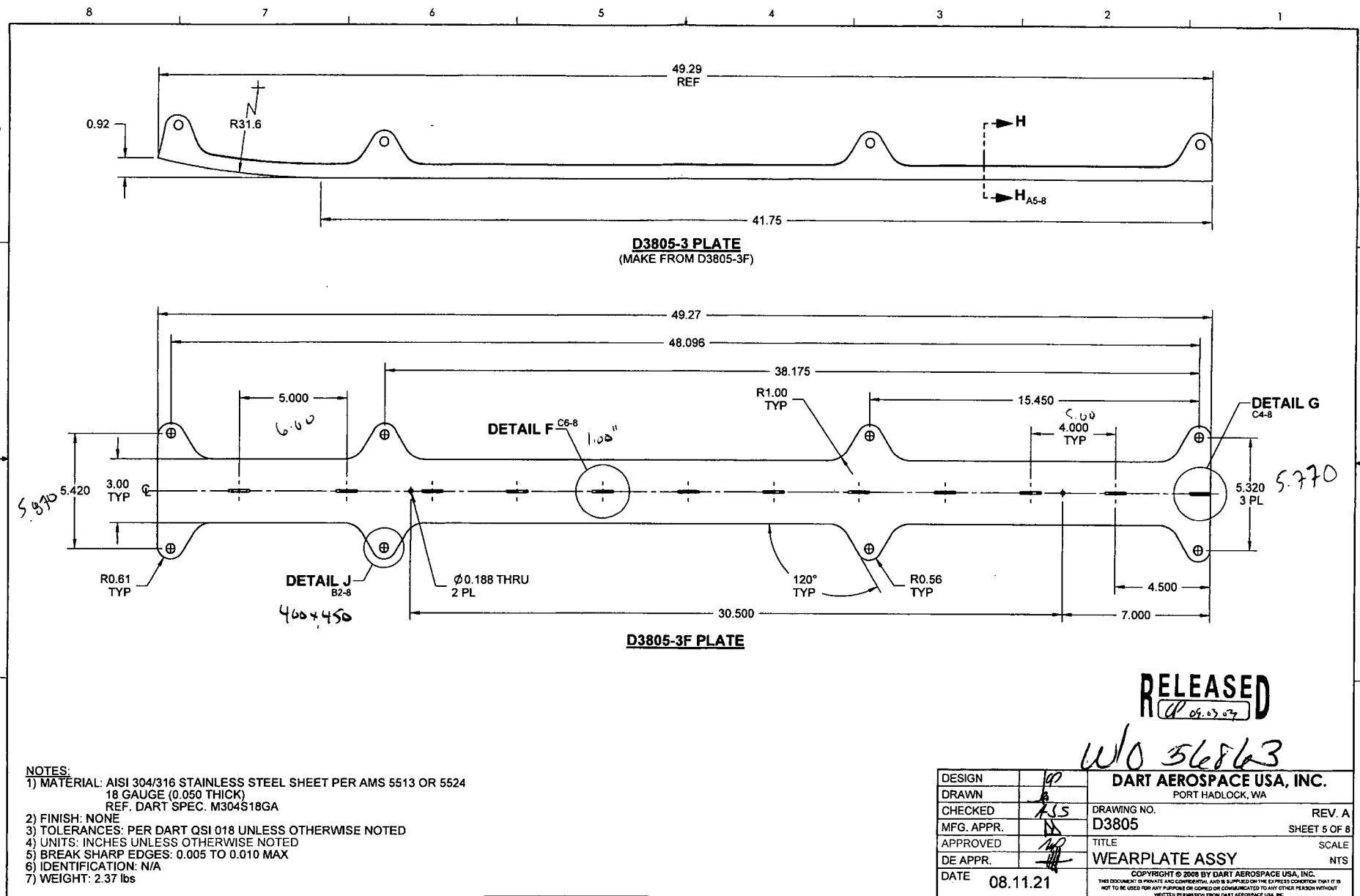
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 2.37 lbs

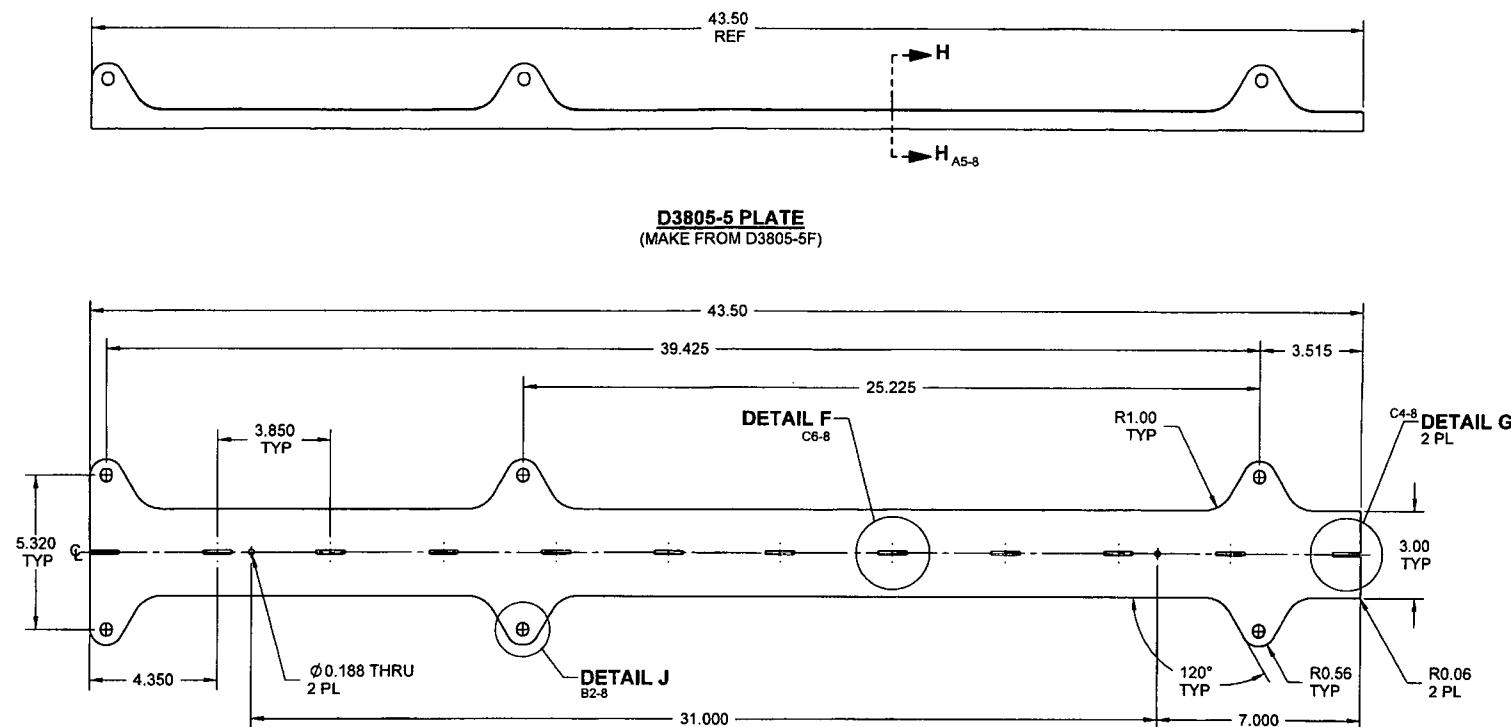
DESIGN	10	DART AEROSPACE USA, INC.		
DRAWN	6	PORT HADLOCK, WA		
CHECKED	115	DRAWING NO.	REV. A	
MFG. APPR.	DN	D3805	SHEET 5 OF 8	
APPROVED	10	TITLE	SCALE	
DE APPR.	10	WEARPLATE ASSY	NTS	
DATE	08.11.21	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC.		
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3805-5F PLATE

RELEASED
CP 09.03.03

410 56863

NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (.050 THICK)
REF. DART SPEC. M304S18GA

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 2.06 lbs

DESIGN	19	DART AEROSPACE USA, INC.		
DRAWN	14	PORT HADLOCK, WA		
CHECKED	ASS	DRAWING NO.	REV. A	
MFG. APPR.	DN	D3805	SHEET 6 OF 8	
APPROVED	WJ	TITLE	SCALE	
DE APPR.	WJ	WEARPART ASSY	NTS	
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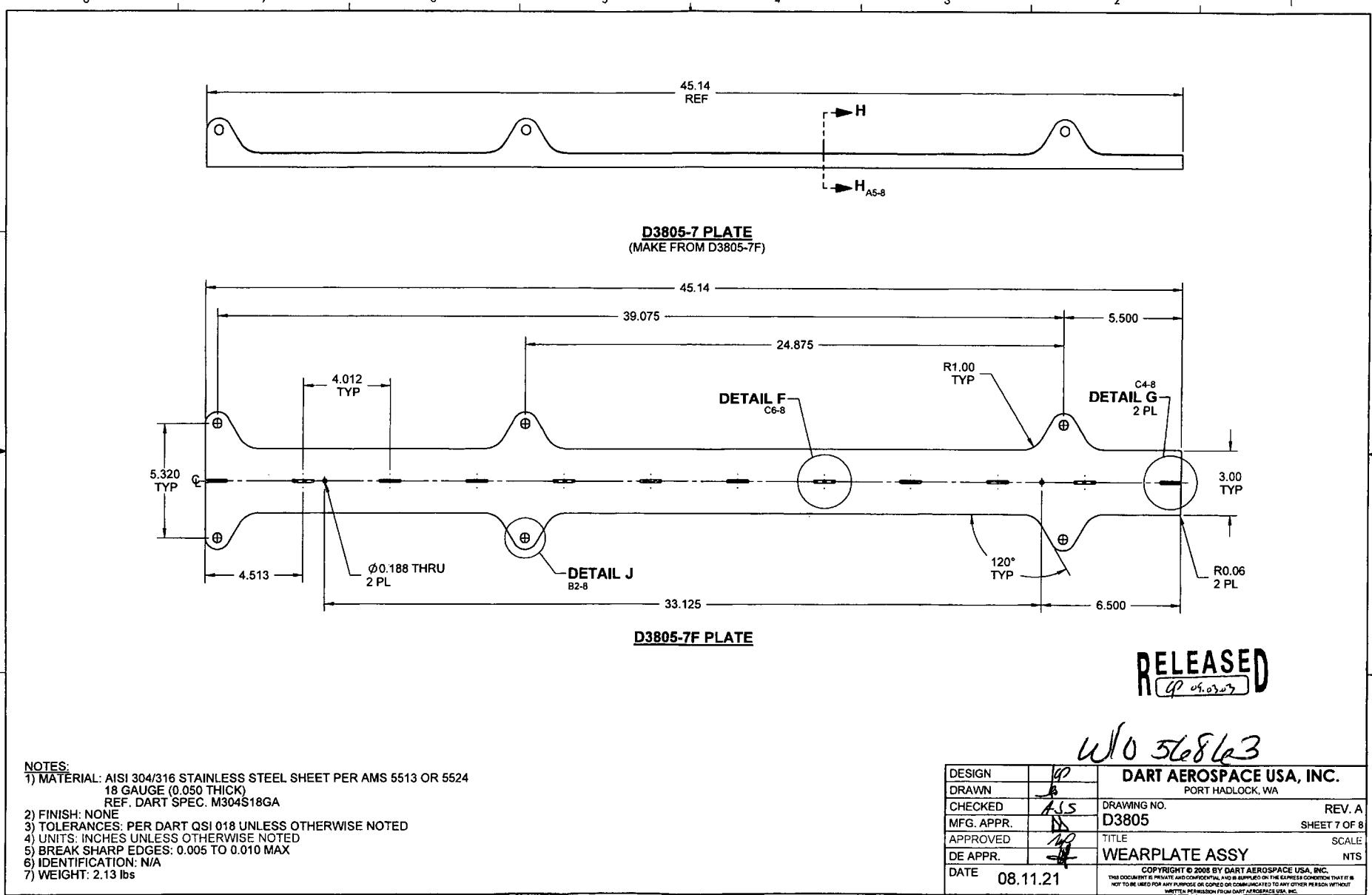
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

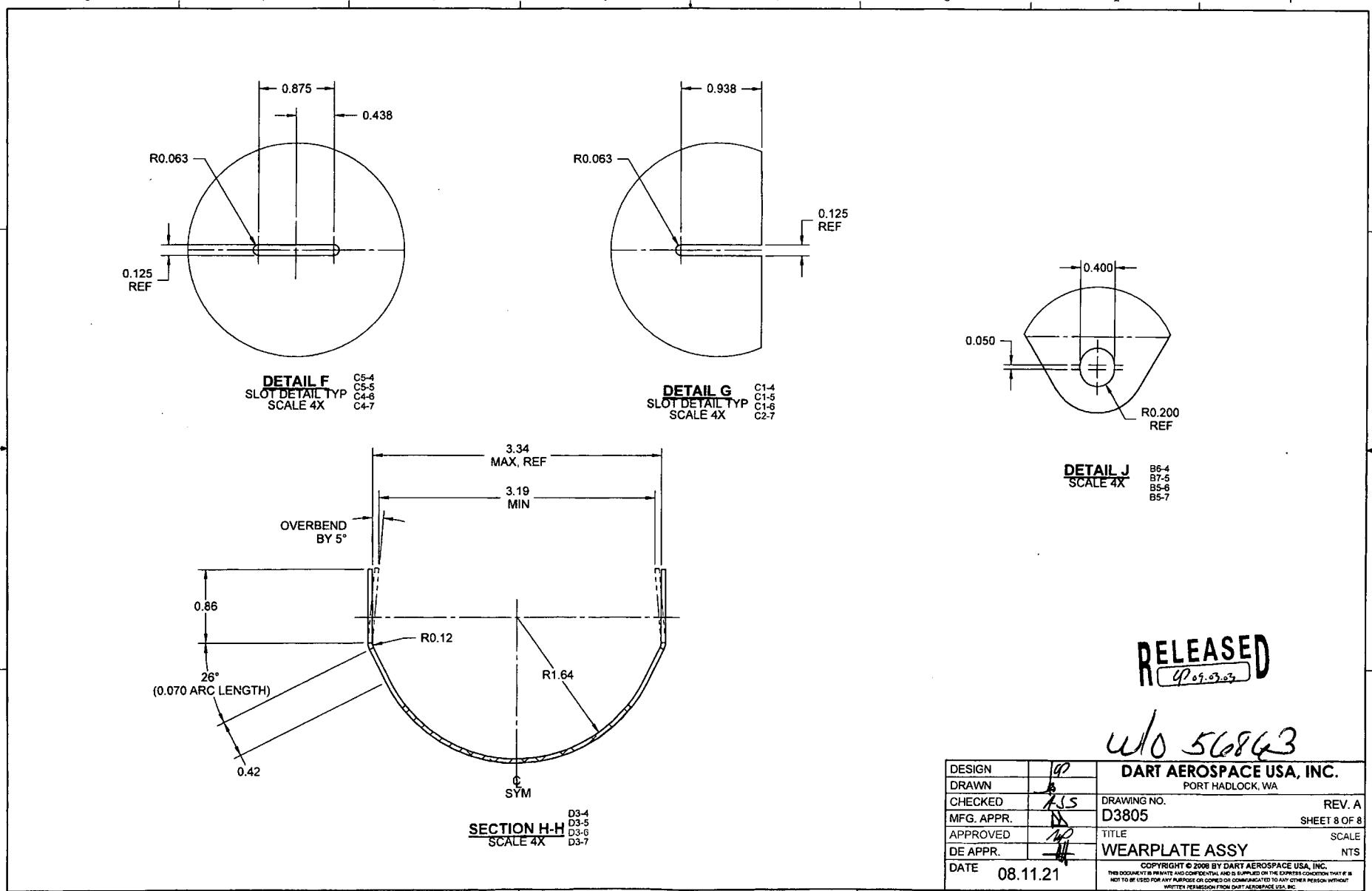


W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	10	DART AEROSPACE USA, INC.
DRAWN	<i>AS</i>	PORT HADLOCK, WA
CHECKED	<i>KJS</i>	DRAWING NO. D3805
MFG. APPR.	<i>NA</i>	REV. A
APPROVED	<i>NA</i>	SHEET 8 OF 8
DE APPR.	<i>NA</i>	TITLE WEARPLATE ASSY
DATE	08.11.21	SCALE NTS

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RELEASED
40-09-03-03

W0 56863

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries